

Date: Tuesday, 16/09/2008 3:28:43 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT BASE ASS'Y		
Job Number	: 42040-2			Part Number	: D3651041		
Estimate Number	: 13043			Drawing Number	: D3651 REV.B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 16/09/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 30/10/2008		Qty: <i>15</i>
Previous Run	: 39931			Um:	Each		
Written By	:			<i>JUL 08.9.16</i>			
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD verofoed by: EC Est Rev:C ecn1162 08-04-02 DD verified by: EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
<b>Comment:</b> PACKAGING RESOURCE #1 Pick Packing Kit			
2.0	D3651043	Flange Weldment	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) FLANGE ASSEMBLY <i>B 40856</i> FF 08/10/02			
3.0	D36511	Gasket	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) GASKET <i>B 42115 /B35844 SB</i>			
4.0	D36519	Inside Doubler	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) DOUBLER <i>① B 37 138 B 42118 SB</i>			
5.0	D365111	Gasket	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) GASKET <i>B 399.38 /B37139 /42116(x4) SB 08/11/25</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:43 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT BASE ASS'Y
Job Number: 42040		Part Number: D3651041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D365113	Outside Doubler 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) DOUBLER ① B37140 B42117 ⑤		SD 08/11/25 1
7.0	CR3523402	RIVET 
Comment: Qty.: 58.0000 Each(s)/Unit Total : 290.0000 Each(s) RIVET ①/109371		SD 08/11/25 1
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: 1-Assemble as per dwg D3651 2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651 Batch: ① 109536 3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651 Batch: ① 105623		PF 08/11/25 ①
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		SP 08/11/25 ①
10.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify with Dart part # using a fine point permanent marker and Stock Location: GA		SD 08/11/25 ①
11.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		08/11/26 ①
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

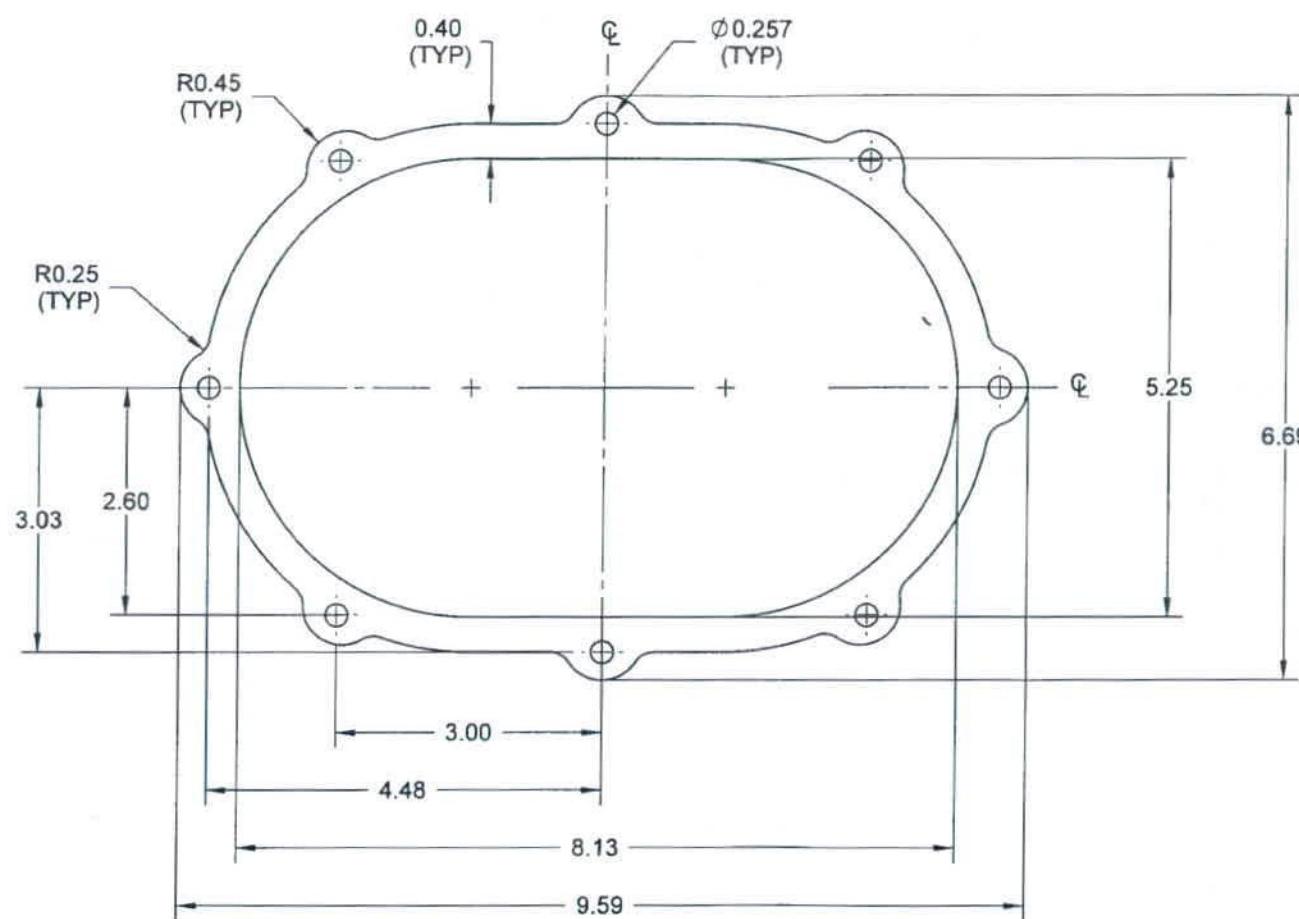
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



D3651-1 GASKET

08-03-27  
M

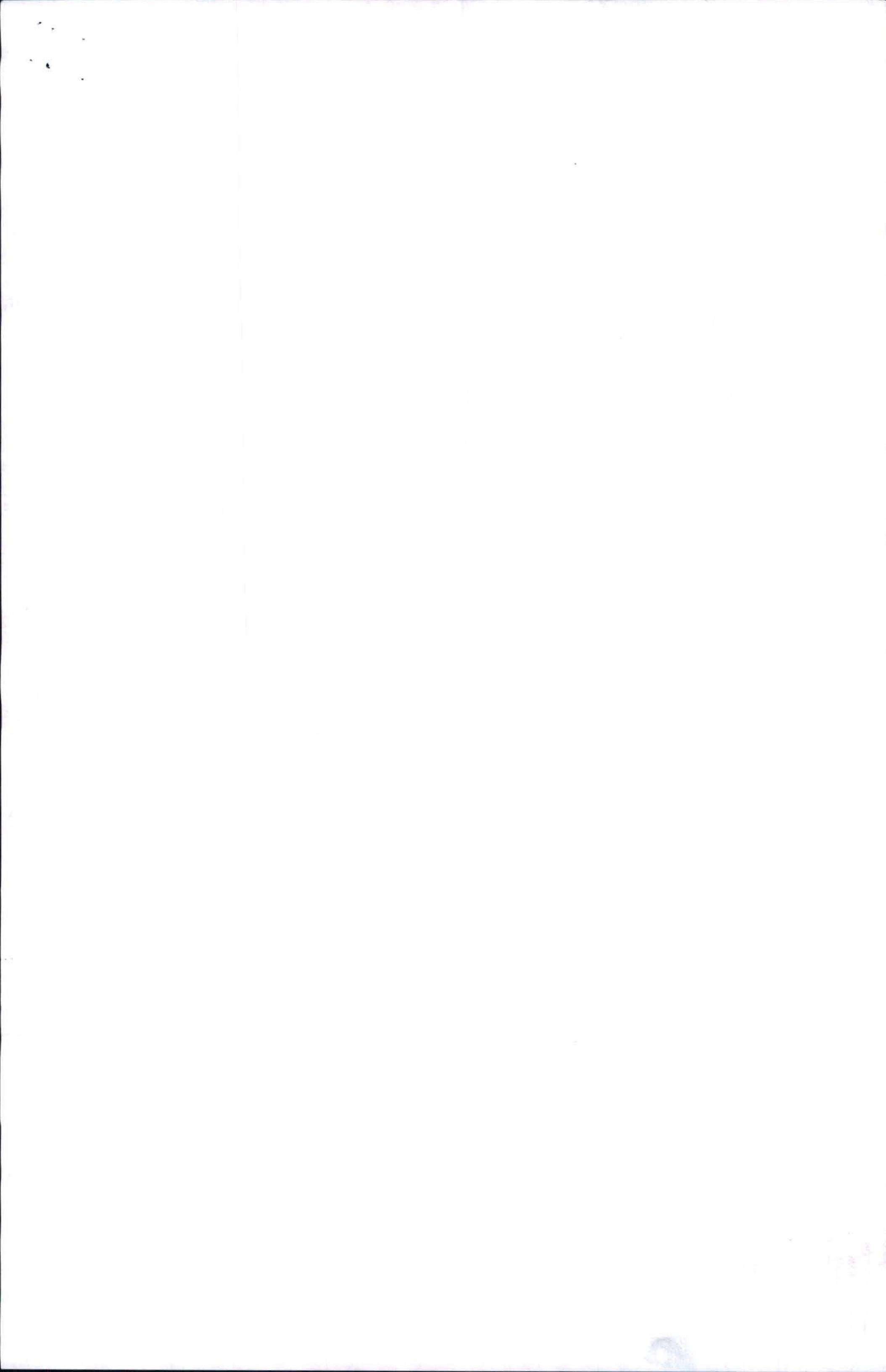
NOTES:

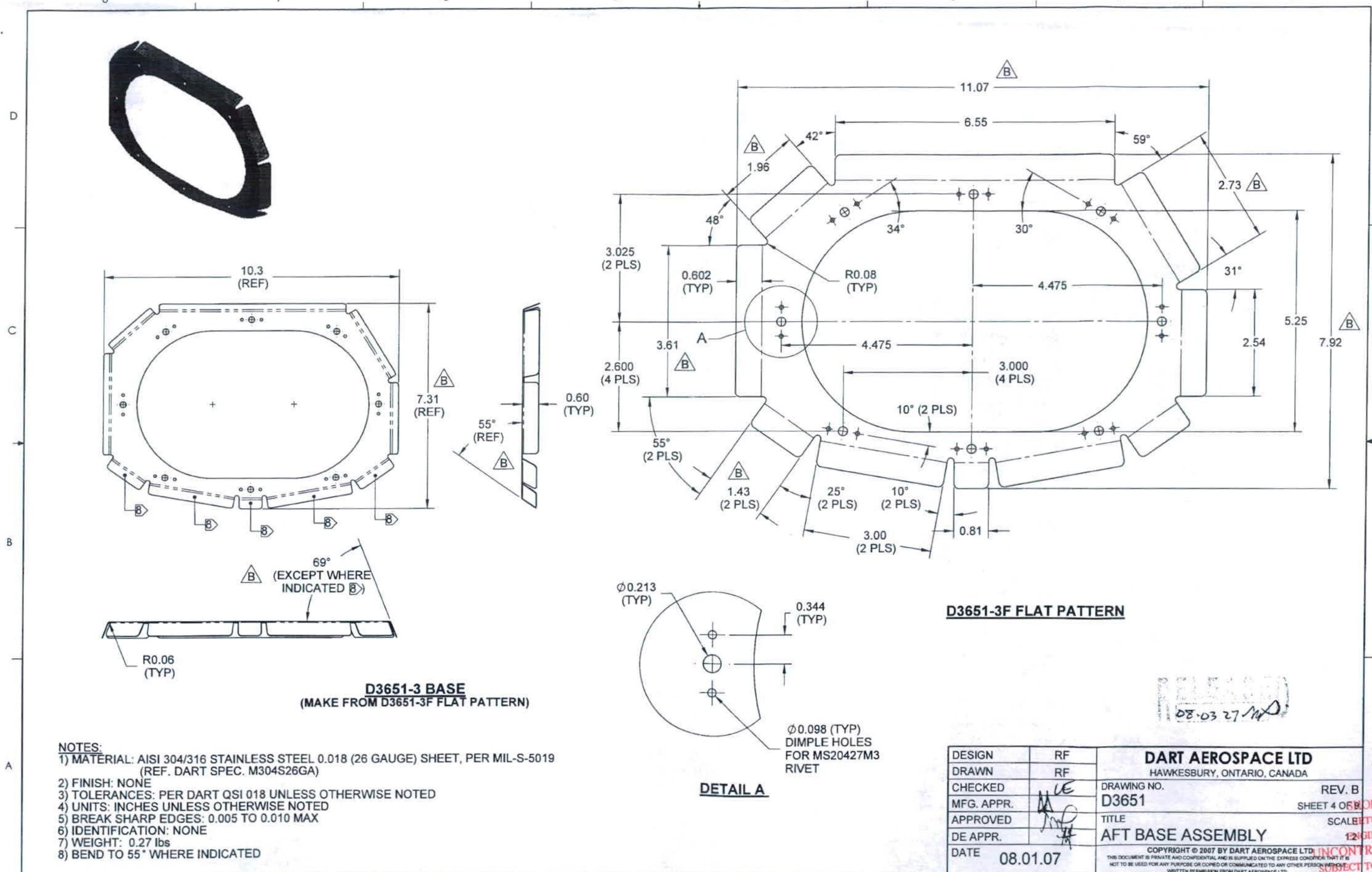
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT  $\frac{C}{2}$
- 8) WEIGHT: 0.09 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>le</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>le</i>	D3651	SHEET 3 OF 9
APPROVED	<i>le</i>	TITLE	SCALE
DE APPR.	<i>le</i>	AFT BASE ASSEMBLY	1:2
DATE	08.01.07	SHOP COPY	RETURN TO
		ENGINEERING	UNCONTROLLED COPY

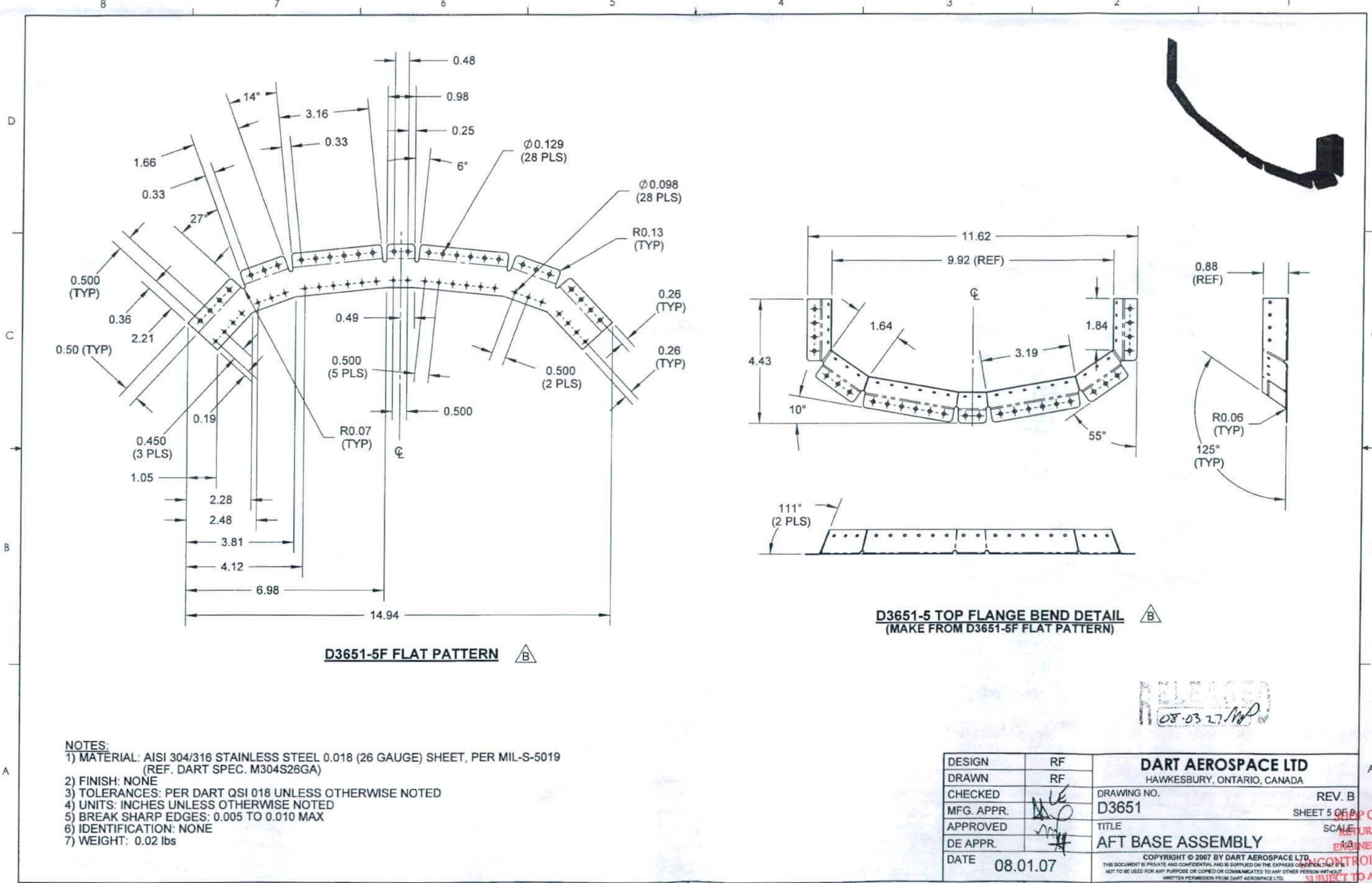
COPYRIGHT © 2007 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42090









## NOTES

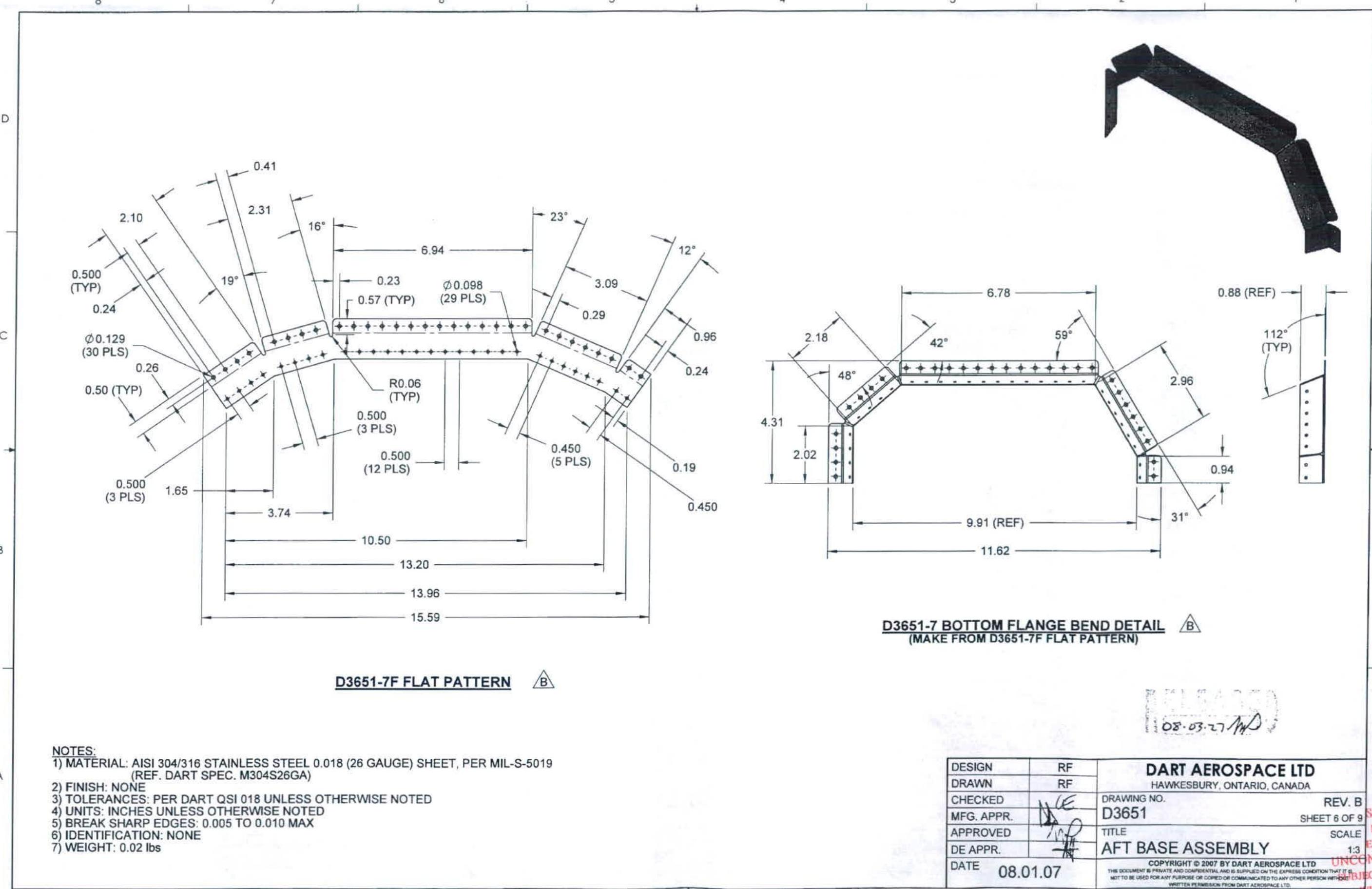
- NOTES:**

  - 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5011  
(REF. DART SPEC. M304S26GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.02 lbs

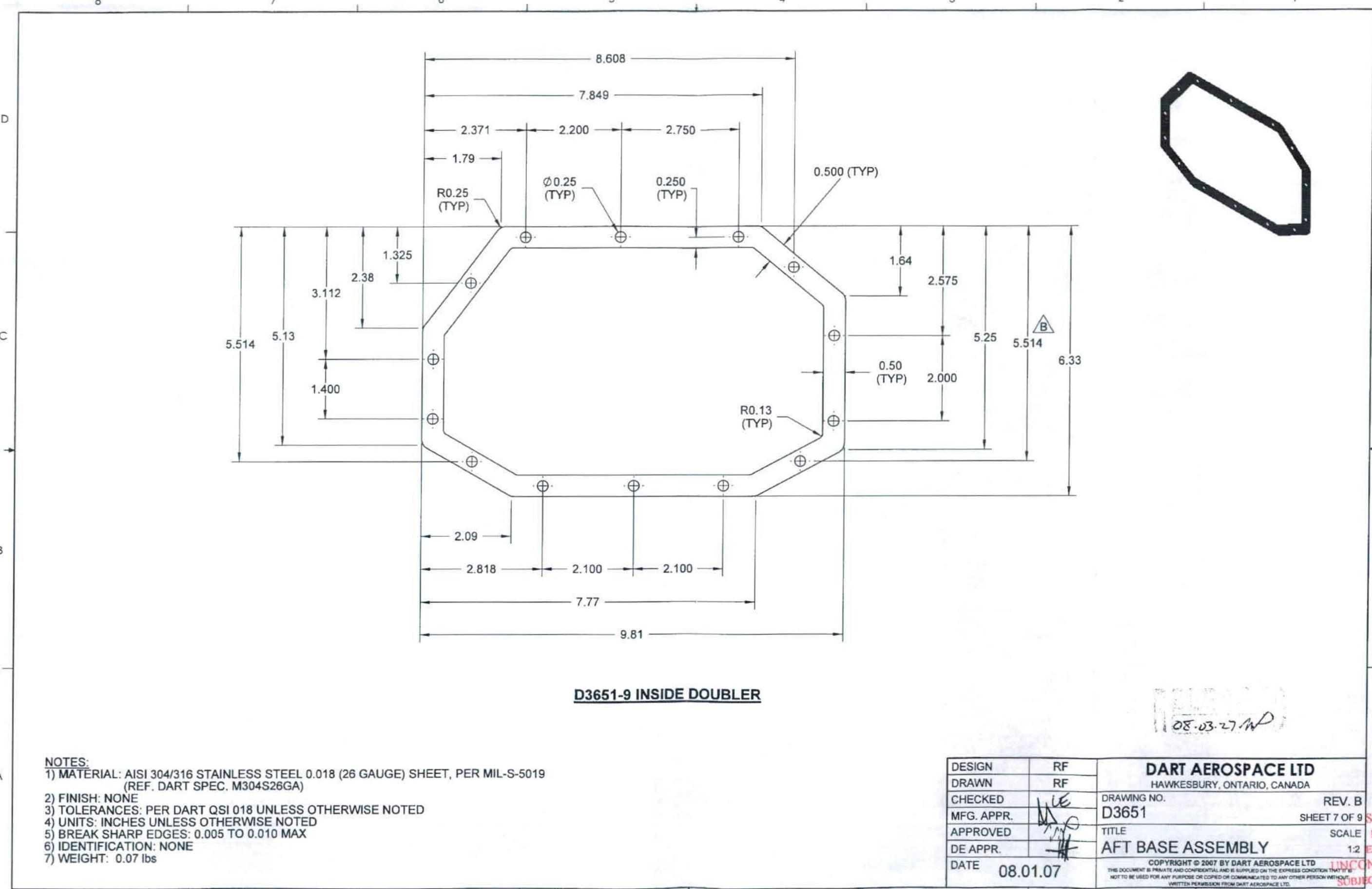
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Le</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AP</i>	D3651	SHEET 5 OF 9
APPROVED	<i>M</i>	TITLE	SCALE
DE APPR.	<i>H</i>	AFT BASE ASSEMBLY	1:1
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8      7      6      5      4      3      2      1      1      WITHOUT NOTICE  
WORK ORDER  
NO. 4000





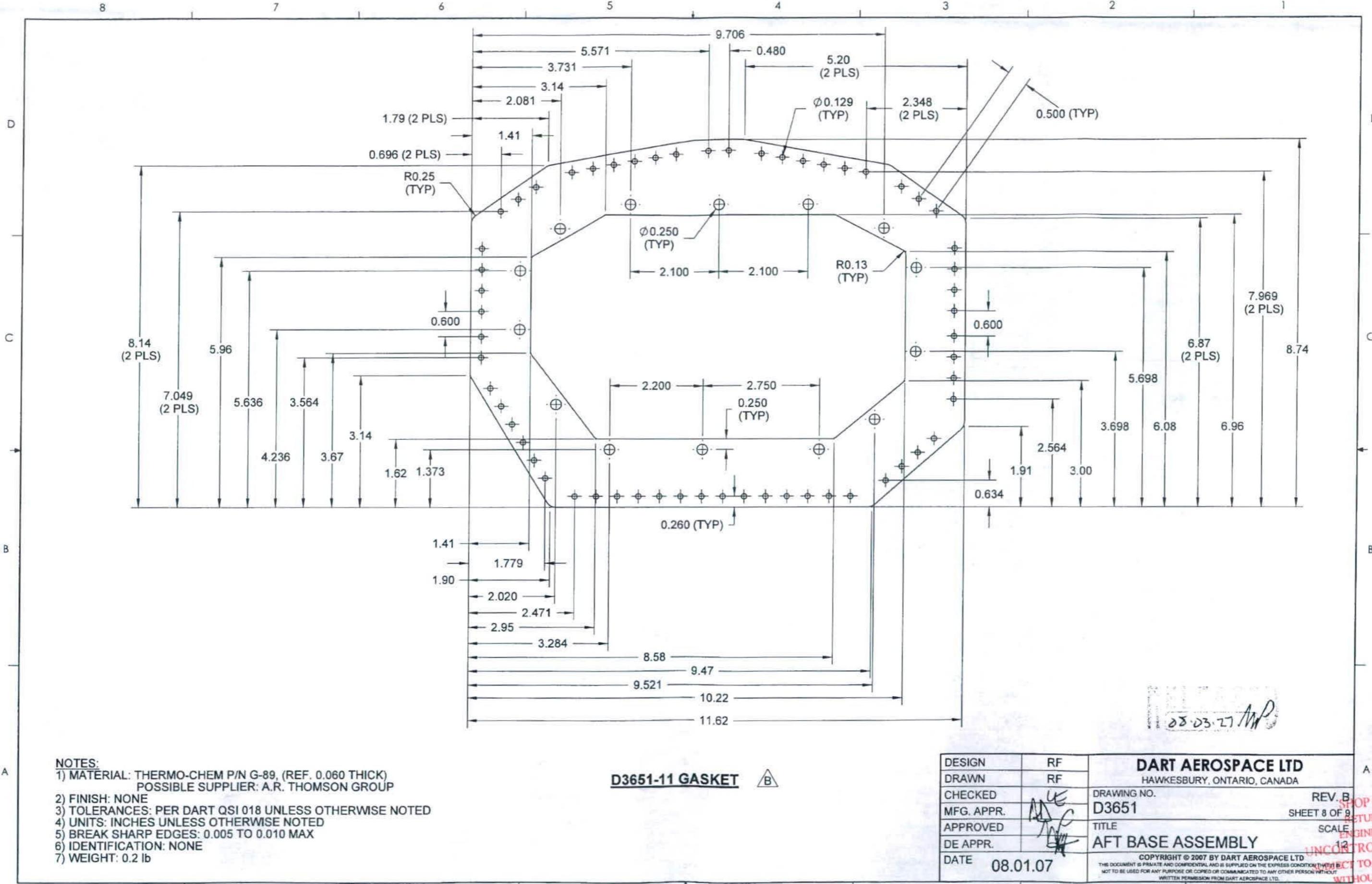




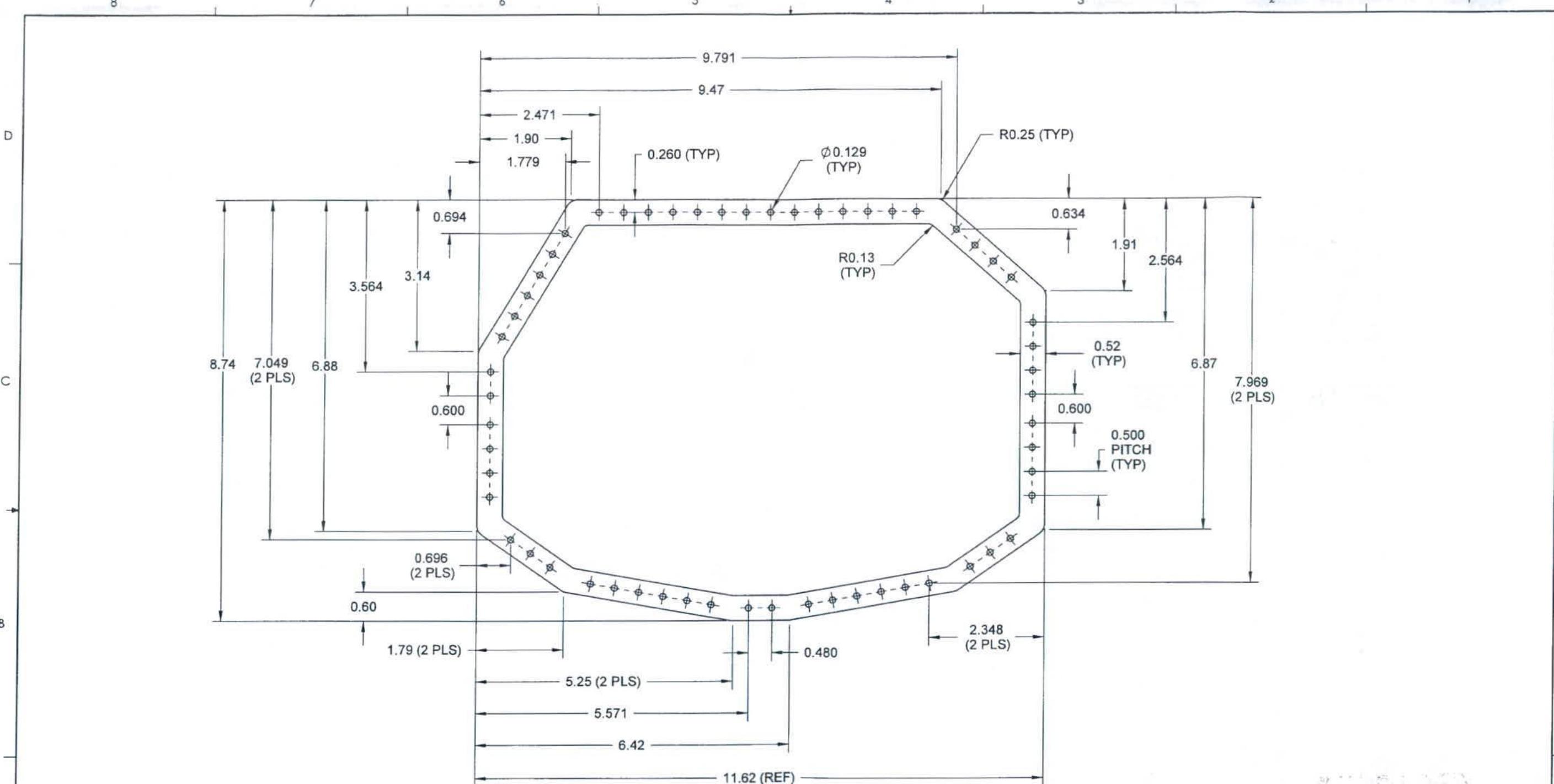
DESIGN	RF	<b>DART AEROSPACE LTD</b>
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>le</i>	DRAWING NO.
MFG. APPR.	<i>le</i>	REV. B
APPROVED	<i>le</i>	D3651
DE APPR.	<i>le</i>	SHEET 7 OF 9
DATE	08.01.07	TITLE
		AFT BASE ASSEMBLY
		SCALE
		1:2
		SHOP COPY
		RETURN TO
		ENGINEERING
		UNCONTROLLED COPY
		SUBJECT TO AMENDMENT
		WITHOUT NOTICE
		WORK ORDER
		NO. <i>42050</i>

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.









D3651-13 OUTSIDE DOUBLER △

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO.
MFG. APPR.		D3651
APPROVED		REV. B
DE APPR.		SHEET 9 OF 9
DATE	08.01.07	SCALE

**AFT BASE ASSEMBLY**

COPYRIGHT © 2007 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42040

